DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-024687
Date Inspected: 23-Jun-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name: Mr. An Qing Xiang

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☐ Yes	☐ No	☑ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

CWI Present: ☑ Yes ☐ No

Bridge No: 34-0006
Component: Orthotropic Box Girder(OBG)

Summary of Items Observed:

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Assembly bay#14.

The following Non Destructive Testing (NDT) Inspection was carried out as per the ZPMC submitted Notification No.09579.

Magnetic Particle Testing (MT)

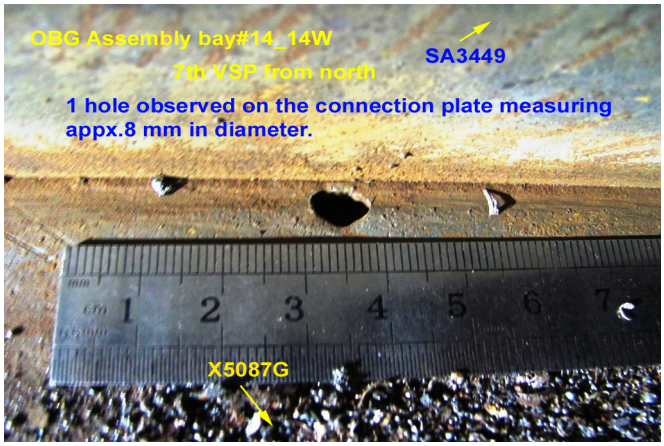
This QA randomly witnessed and performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated a MT report for this date. The members are identified as OBG weld Components. Total number of welds MT witnessed: (80) and tested(40).The weld designation inspected was as follows:

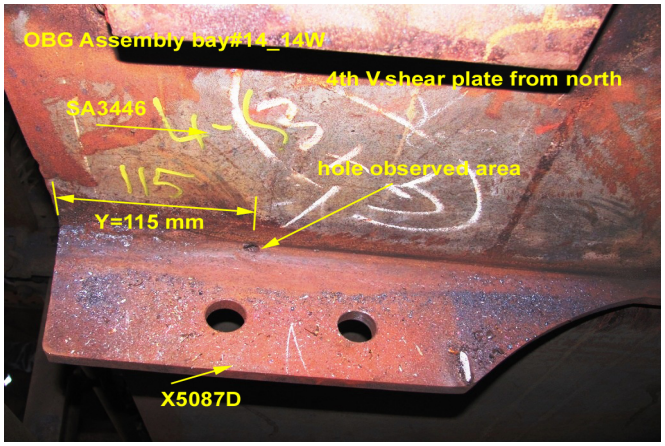
1. SEG3020W-079,081,087,089,084,085
2. SEG3020AT-006,016,017,021,027,028,038,042,047,049,059,069,080,085,178,108,120,129,133,137,145,146, 187
3. SEG3020BC-046,048,022

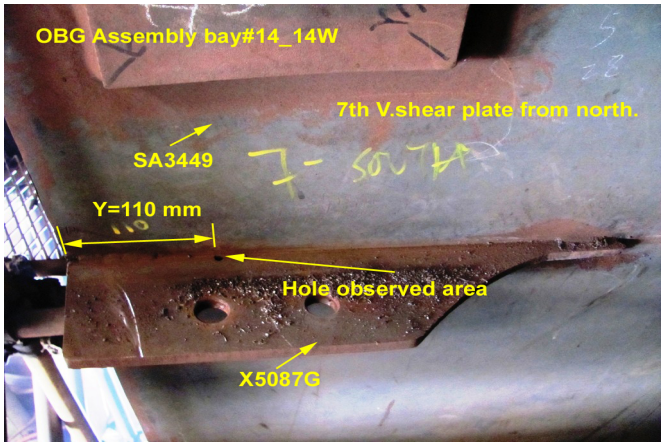
4. SEG3020BB-110~117,019,028,055,002,029,047,065,070,008,009,083,087,088,062,098
5. SEG3020AJ-017,465,020,021,123,099,102,109,114,157,088,153,066,471,069,070,148,073,143,463,478, 467~470.

During random in process visual inspection of OBG sub assembly members identified as vertical shear plates SA3446,49 and 50, this QA observed 4 holes on the connection plates measuring approximately 5~10 mm in dia. The connection plate members are identified as X5087D, G and H respectively. The connection plates designated as Seismic Performance Critical Material (SPCM) on the approved shop drawing. The “Y” locations measured from the west side end of the connection plates as shown on the picture below. The thickness of the connection plates is 14 mm. This QA marked the affected areas and informed ZPMC Quality Control (QC) CWI indentified as Mr. An Qing Xiang and QC identified as Mr. Sun tian liang and Mr. Zhulin of this issue. These QC personnel informed this QA that the holes would be corrected in a manner compliant with the contract documents. This QA Inspector also informed to American Bridge/Fluor QA Inspector identified as Mr. Zhang Qili and CT Lead QA Inspector of the issue. See attached photos for further details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.







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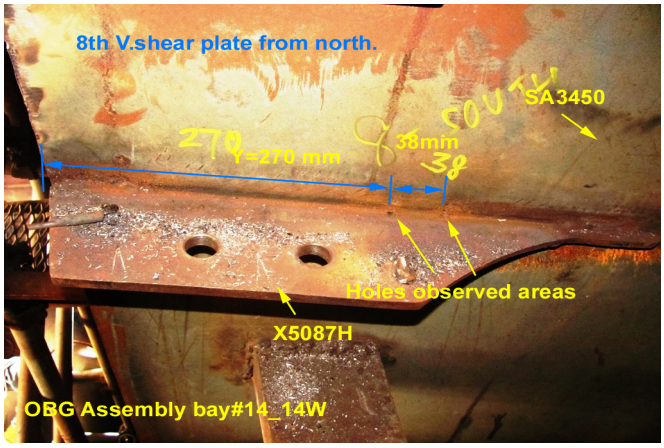

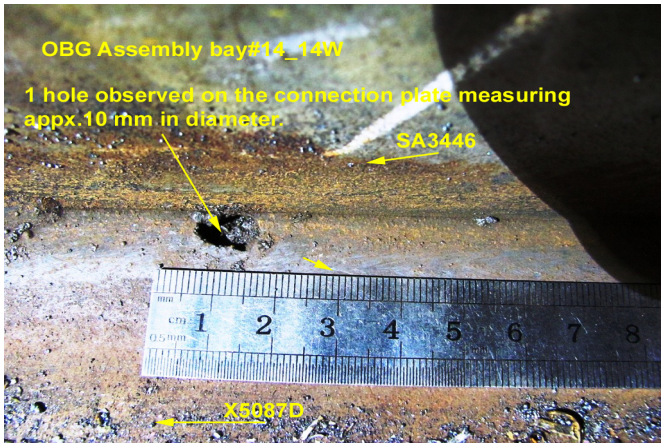

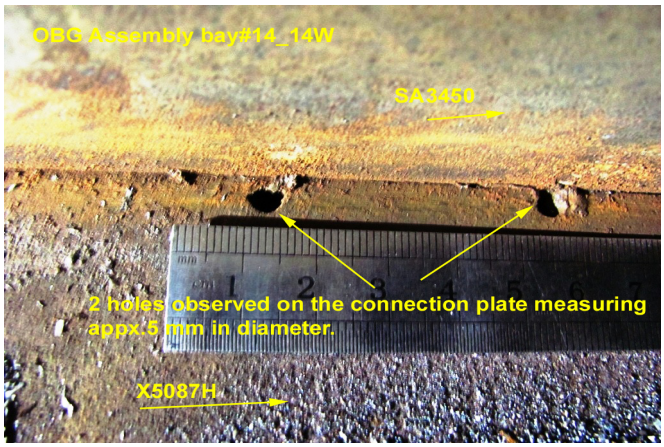

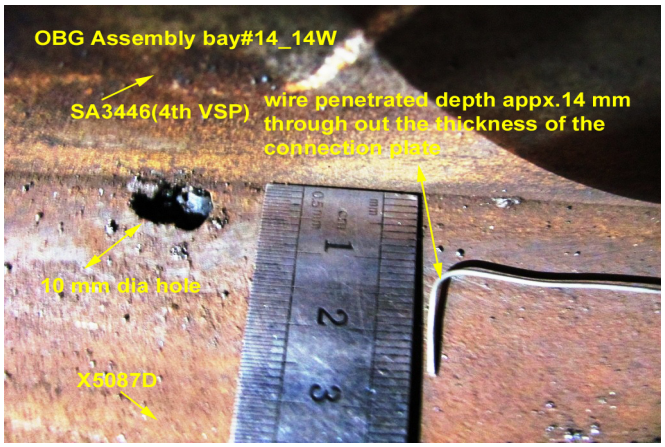

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer